

Work Order ID 163559

Wednesday, June 28, 2017 3:38:59 PM

163559

Page 1

Item ID: D4941-3L08 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector, Aft LH, (Clear)
Start Date: 7/5/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 7/12/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan:  Date: JUN 28 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4941	D								

110

0.00

110

Purchasing

Purchasing

THERMOFORMING MACHINE

Memo

ISSUE P/O: 37041
SUPPLIER: PLASTECH

MANUFACTURE D4941-3L08 AS PER DWG

C OF C IS REQUIRED

5

DAS
13
9-89

JLB 7/10/13

0.00

140

140

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs
HAND FINISHING THERMOFORMING

Memo

0.00

0.00

5x SP17-9-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

163559

Wednesday, June 28, 2017 3:38:59 PM

N900040100

Setup Start *NS1*

Stop *NS2*

5

Cust Item ID:

Start Date: 7/5/2017 **Start Qty:** 5.00

Required Date: 7/12/2017 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

150

0.00

QC

Memo

Quality Control

POSITIVE RECALL
EFFECTIVE JUL 11 2017 AUTH MA
RELEASED BD DATE 11-09-20

Identify as per dwg & Stock Location: St

0.00

170

Packaging

Memo

0.00

Packaging

SEP 20 2017

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

WM 17/9/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
POSITIVE RECALL EFFECTIVE DATE RELEASED DATE								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Work Order ID: 163559

163559

Parent Item: D4941-3L08

D4941-3L 08

Parent Item Name: Floor Protector, Aft LH, (Clear)

Start Date: 7/5/2017

Required Date: 7/12/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev A New Issue 13/12/16 DL
 Revised dimensions 14/02/12 DL
 14/07/02 DL
 IPP Rev B
 IPP Rev C Revised Dwg.
 IPP Rev D Revised Dwg. 14/07/25 DL
 IPP Rev.E 17.06.13 Now outside process DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4941-3L08P		Purchased	No			110	Each	0.0000	1	5			
D4941-3L 08P									**				
Floor Protector, Aft LH, (Clear)													
MLEXS.118-90318-08		Purchased	No			110	sf	194.5690	4.875	24.375			
MI FXS 118-90318-08									**				
Lexan Sheet (Clear)													

5x SP 17-9-12.

SEP 21 2017

M138294

Location

Loc Qty

Loc Code

RM

194.56897

m126994

194.56897

DQA: _____ Date: _____

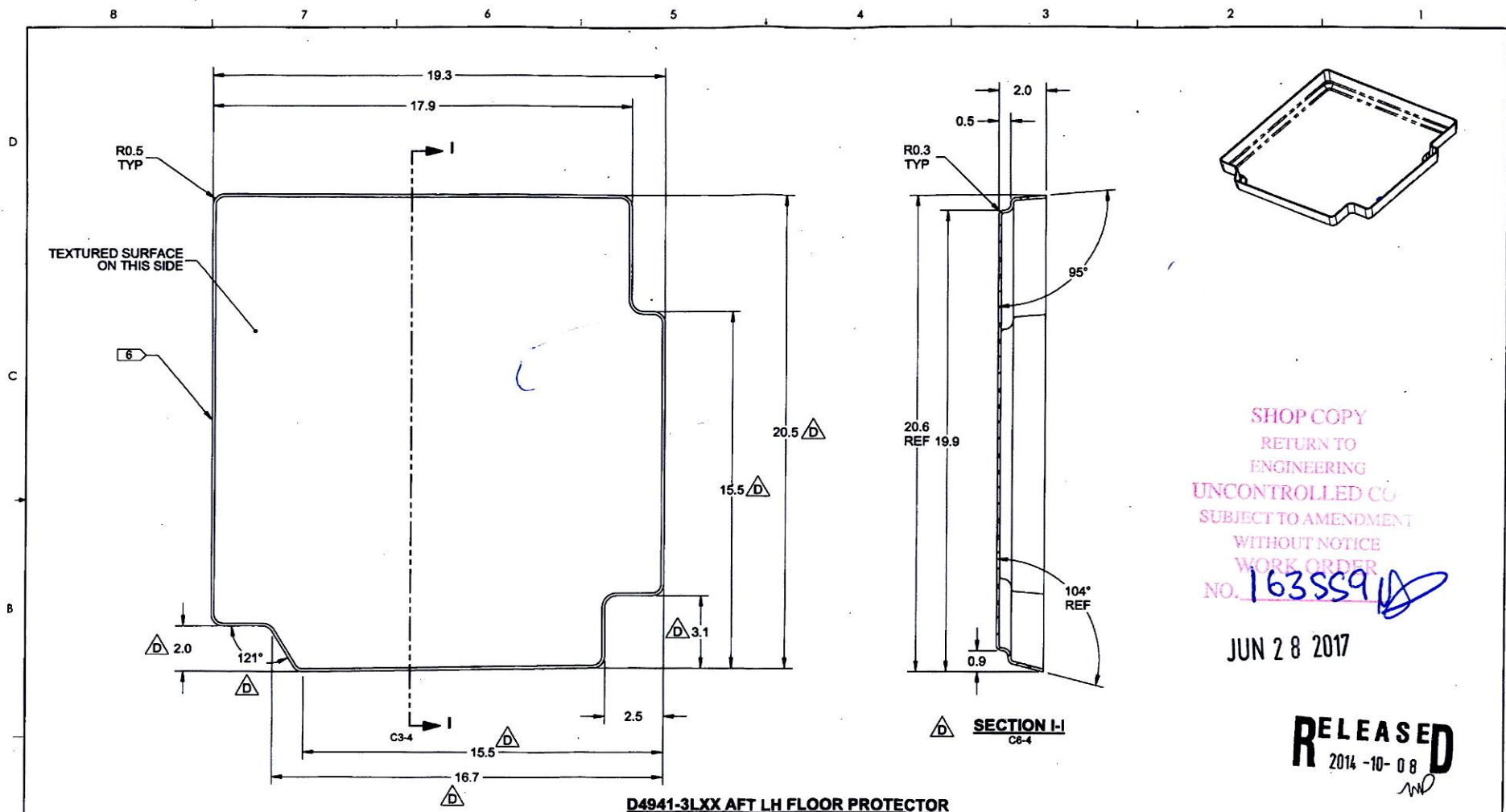


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163SS9

JUN 28 2017

RELEASED
2014-10-08

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4
- 7) WEIGHT: 1.8 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9992
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

PART NUMBER	DESCRIPTION
D4941-3L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-3L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

DESIGN		AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D SHEET 4 OF 5 SCALE NTS	
DRAWN		AK			
CHECKED		VS			
MFG. APPR.		DL			
APPROVED		HS			
DE APPR.		DS	TITLE CABIN FLOOR PROTECTORS		
DATE		14.07.25	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37041**

Purchase Order Date 7/13/2017

PO Print Date 7/14/2017

Page Number 2 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	D4941-3L08P	Floor Protector, Aft LH, (Clear)	8/3/2017	5.00	\$65.00	\$325.00
			Yes	Each		
			8/3/2017			

As per dwg D4941
REV. D
B163559

PD 12.29.20

8/17 9-12

Line Total: \$325.00

4	D4941-4L08P	Floor Protector, Aft RH, (Clear)	8/3/2017	5.00	\$65.00	\$325.00
			Yes	Each		
			8/3/2017			

As per dwg D4941
REV. D
B163562

Line Total: \$325.00

Note:

7/14/2017



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24292
Shipment Date: 09/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37041
Carrier Account #

Sales Order
SO-019295

Incoterms
EX WORKS

Payment Method
PPD/CHG
Tracking Number

Ship Via
FREIGHTCOM INC. -

Item Number - Revision Description

D4941-1L08 - Rev.: D CABIN FLOOR PROTECTORS
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-2L08 - Rev.: D CABIN FLOOR PROTECTORS
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

✓ D4941-3L08 - Rev.: D CABIN FLOOR PROTECTORS
PO HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-4L08 - Rev.: D CABIN FLOOR PROTECTORS
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

Quantity UOM
Shipped

5 EA

5 EA

5 EA

5 EA

SP A-9-12

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37041 SO # 019295

Part #	D4941-1L08	Qty.	5	Batch #	-001
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-2L08	Qty.	5	Batch #	-002
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-3L08	Qty.	5	Batch #	-003
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-4L08	Qty.	5	Batch #	-004
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: SEPT. 7, 2017 COFC# 011
(Approved QA Signatory)

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Inspection Checklist

COPY

PLAS-TECH
Think Plastics™

Customer: Dart Aerospace Ltd

SO # 019295-003

Description: Floor Protector, LH Aft

Part #: D4941-3L02/L08

Inspection Dwg: D4941

Rev: D

Page: 1 of 1

Inspection Checklist: ☐ First Article

☐ Prototype

☒ First Off

Thermoforming Section

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratches	✓			

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Trimming Section

Drawing Dim.	Tolerance	Actual Dimensions	Accept	Reject	Method of Inspection	Comments
19.3	+/- 0.100	19.3	✓			
17.9	+/- 0.100	17.88	✓			
20.5	+/- 0.100	20.5	✓			
15.5	+/- 0.100	15.5	✓			
3.1	+/- 0.100	3.1	✓			
16.7	+/- 0.100	16.7	✓			
2.0	+/- 0.100	2.0	✓			
2.0	+/- 0.100	1.96	✓			
0.070	Min	N/A				

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Approval by: _____

Date: _____

Rev.	Date	Change	Revised by	Approved